

Work Order ID 97339

February-15-13 10:03:29 AM

97339

Page 1

Item ID: D2563

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Weldment Assembly

Start Date: 2/15/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/01/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-02-15 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

5 Ø Ac 13-03-06
13-03-27
Ac 13-03-27

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

(5) 13-03-27 DAS
09
0-09

97339

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 2/15/13 **Start Qty:** 5.00

5

Customer:

Required Date: 3/01/13 **Req'd Qty:** 5.00

5

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00
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120

QC Memo

Quality Control

130	Chemical Conversion Coat per QSI005 4.1	0.00
-----	---	------

130

HandFinish Memo

Hand Finishing

140	QC1 Inspect Part Finish	0.00
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140

QC Memo

Quality Control

97339

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

5

Required Date: 3/01/13 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Weld per dwg A/R Aluminum rod Batch: <u>122324</u>	0.00							
150	Large Fab					5	φ		
Large Fab	Memo	0.00							13-03-27
Large Fab	1-Inspect for foreign object per QSI 024								13-03-27
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160	QC10- Inspect visual per QSI004- ground welds	0.00							
160	QC					⑤	B-03-27		DAS 09 2-89
Quality Control	Memo	0.00							
170	QC5- Inspect part completeness to step on W/O	0.00							
170	QC					⑤	B-03-27		DAS 09 2-89
Quality Control	Memo	0.00							

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Stop ***NS2***

Item Name: Step Weldment Assembly

Start Date: 2/15/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/01/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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175 Pressure Wash per QSI005 4.3

0.00

175

HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

5 RB 3-3-28

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320°F
10:00
124376

Wing Walk as per dwg QSI005 4.4 Batch 124376

0.00

190

190

HandFinish

Memo

0.00

Hand Finishing

5X M/ 13/03/28

50 B-4-2

M124245

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Item Name: Step Weldment Assembly

Start Date: 2/15/13 Start Qty: 5.00

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Cust Item ID:

Required Date: 3/01/13 Req'd Qty: 5.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC3- Inspect Part Finish

0.00

13.4.2

200

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

PP 92370 (X41)
98813 X1

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

13/4/4

13-04-4

Picklist Print

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Work Order ID: 97339

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 2/15/13

Required Date: 3/01/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116

Manufactured No

100

Each

101.2105

1

5

D2244-116

Step Extrusion

**

Ac 13.03.06

Location

Loc Qty

Loc Code

WA

-0.0000368

WA003

101.2104894

60307

2

80803

19.2104894

89954

80

D2561

Manufactured No

100

Each

44.0000

2

10

D2561

Lug

**

13.03.25

Location

Loc Qty

Loc Code

WA003

44

66813

5

86371

39

D2564

Manufactured No

100

Each

44.0000

2

10

D2564

Mounting Angle

**

13.03.25

Location

Loc Qty

Loc Code

WA003

44

85831

20

92557

24

8
2

Picklist Print

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Work Order ID: 97339

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 2/15/13

Required Date: 3/01/13

Start Qty: 5.00

Required Qty: 5.00

D2673-34

Manufactured No

100

Each

44.0000

1

5

D2673-34

**

13.03.25

End Plate

Location

Loc Qty

Loc Code

WA003

44

88900

44

D2673-34

Manufactured No

150

Each

44.0000

1

5

D2673-34

**

13.03.27

End Plate

Location

Loc Qty

Loc Code

WA003

44

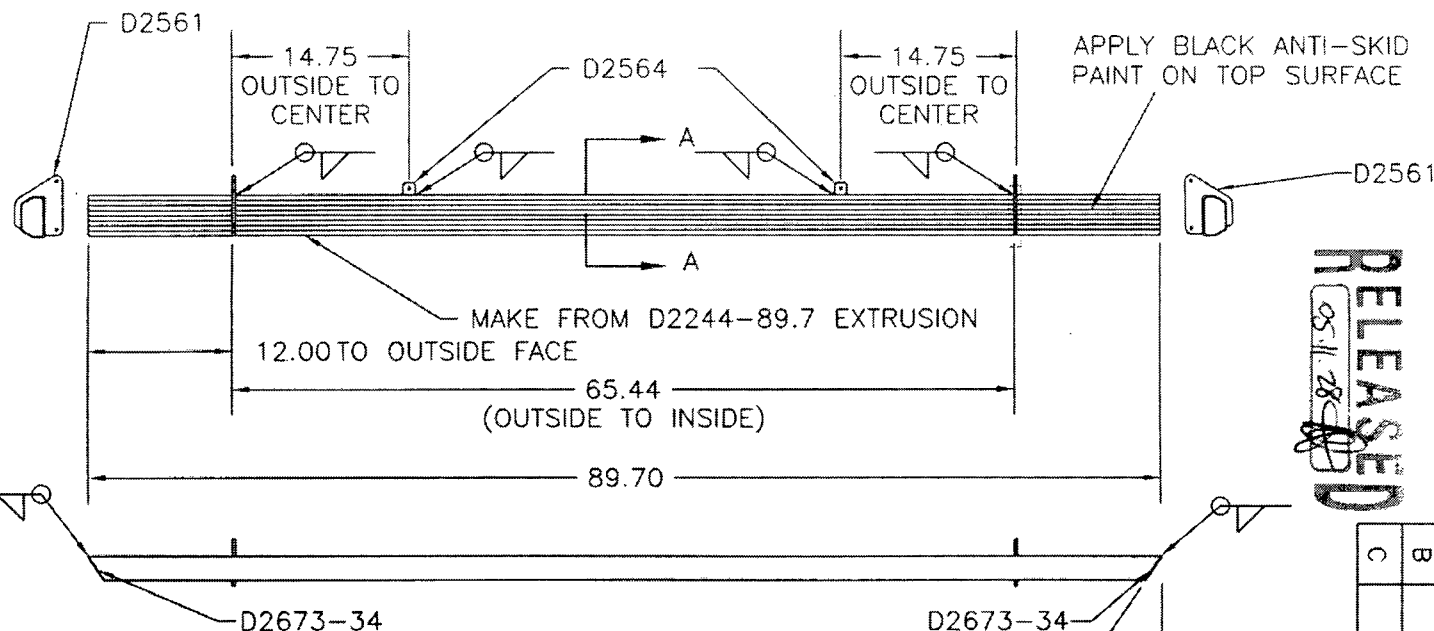
88900

44



RELEASED
05.11.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		H		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. C	
		D2563		SHEET 1 OF 1	
DATE		TITLE		SCALE	
05.11.14		STEP WELDMENT ASSEMBLY		1:15	
A	96.04.26	NEW ISSUE			
B	97.05.14	END CAPS CHANGED (WAS D2248)			
C	05.11.14	UPDATE NOTES			



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP
REWORK
ENGINEER
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK CENTER

NO. 97.339.MLS
13-02-15

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

